



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5331-041
Job Sheet 187738



Part No: D5331-041

Job Qty: 1 ea

Part Name: Basket Base Assembly, LH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/13/18

Job Tracking No:

Due Date: 12/28/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV B SHEETS 1,2,4,5,6,7,8 IPP REV:A 15.10.15 NEW ISSUE DD VERF:JLM IPP REV:B 17.03.27
add D4016-7 DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	12/28/18	12/28/18	0.00	0.00	Start Up Large Fab-6		
100	Large Fab	1 pcs	12/28/18	12/28/18	0.00	15.77	Large Fab 1	DAS 24 9-89	
110	QC	1 pcs	12/28/18	12/28/18	0.00	0.00	QC9		
120	QC	1 pcs	12/28/18	12/28/18	0.00	0.00	QC5		
125	HandFinish	1 pcs	12/28/18	12/28/18	0.00	2.34	HandFinish2		
130	Powdercoat	1 pcs	12/28/18	12/28/18	0.00	0.53	Powdercoat2		
140	QC	1 pcs	12/28/18	12/28/18	0.00	0.00	QC3		
170	Packaging	1 pcs	12/28/18	12/28/18	0.00	0.00	Packaging3-2		
180	QC21-SA	1 Ea	12/28/18	12/28/18	0.00	0.00	QC21		

Part Op 100 - 1- Assemble ribs and weld as per dwg D5331 using DT10197 ***inspect before welding mesh*** (54.63)
Descriptions: CRITICAL DIMENSION)*** 2- Weld gusset and handle plate as per dwg 3- Cut mesh as per dwg D5328-1 4- Tack weld mesh on basket as per dwg D5331 and trim mesh to fit if necessary and trim to clear fasteners holes on the ends 5- Weld hinge (6) and Mounting brackets (2) as per dwg D5331 ***Take lid to locate hinge and bracket*** ***On one of the hinge weld stopper D4016-7 as per dwg*** 6- Weld D5325-5 foot as per dwg (CRITICAL)
130 - 1- Plug holes and mask only interior of hinge (6) prior to powder coat 1ST COAT: START TIME: 3:40
OVEN TEMPERATURE: 375 FINISH TIME: 3:55 *****2nd coat if necessary***** 2ND COAT: START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581	Mounting Bracket	2 pcs (2 ea)	90-Start up Operation	5125289
D3913-15	Wide Handle Plate	1 pcs (1 ea)	90-Start up Operation	5115269
D3916-5	Light Rib	2 Ea (2 ea)	90-Start up Operation	5127213 5 141287
D4016-1	Hinge Half, Base	6 Ea (6 ea)	90-Start up Operation	5115309
D4016-7	Stop	1 Ea (1 ea)	90-Start up Operation	5097165
D4021-1	Handle Plate	1 Ea (1 ea)	90-Start up Operation	5126559
D5325-041	Rib Assembly	1 Ea (1 ea)	90-Start up Operation	5150825
D5325-3	Light Rib	1 Ea (1 ea)	90-Start up Operation	5127163
D5325-5	Foot	4 Ea (4 ea)	90-Start up Operation	5154196
D5326-041	Rib Assembly	1 Ea (1 ea)	90-Start up Operation	5126564
D5326-043	Rib Assembly	1 Ea (1 ea)	90-Start up Operation	5109804
D5327-1	Rib	1 Ea (1 ea)	90-Start up Operation	5138436
D5327-11	Rib	4 Ea (4 ea)	90-Start up Operation	5140925

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

D5327-13 ✓	Rib	1 Ea (1 ea) ✓	90-Start up Operation	5067675
D5327-15 ✓	Cap	1 Ea (1 ea) ✓	90-Start up Operation	5108289
D5327-3 ✓	Rib	1 Ea (1 ea) ✓	90-Start up Operation	5127015
D5327-5 ✓	Rib	1 Ea (1 ea) ✓	90-Start up Operation	5127616
D5327-7 ✓	Rib	1 Ea (1 ea) ✓	90-Start up Operation	5127694
D5327-9 ✓	Rib	2 Ea (2 ea) ✓	90-Start up Operation	5127060
D5328-3	Mesh Base, Aft	1 Ea (1 ea)	90-Start up Operation	5144989
D5328-5 ✓	Mesh Base, Fwd	1 Ea (1 ea) ✓	90-Start up Operation	5118091
D5329-1 ✓	Gusset	2 Ea (2 ea) ✓	90-Start up Operation	5089969
D5330-1 ✓	Handle Plate	2 Ea (2 ea) ✓	90-Start up Operation	5054668
M304EX0.75-16F	Expanded Metal Flat SS	32 sf (32 ea)	90-Start up Operation	5147379

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2581	2	34	0
	D3913-15	1	7	0
	D3916-5	2	12	0
	D4016-1	6	181	0
	D4016-7	1	8	0
	D4021-1	1	21	0
	D5325-041	1	0	0
	D5325-3	1	1	0
	D5325-5	4	0	0
	D5326-041	1	4	0
	D5326-043	1	2	0
	D5327-1	1	0	0
	D5327-11	4	2	0
	D5327-13	1	6	0
	D5327-15	1	15	0
	D5327-3	1	3	0
	D5327-5	1	3	0
	D5327-7	1	3	0
	D5327-9	2	6	0
	D5328-3	1	0	0
	D5328-5	1	4	0
	D5329-1	2	4	0
	D5330-1	2	2	0
	M304EX0.75-16F	32	1,818	0

Part Specifications

Specifications could not be found.

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____		Sequence #: _____		QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation				Disposition			
				Completed By			
				Lead hand / Supervisor			
				QC / QA Coordinator			
				FAULT CATEGORY			
				☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up			
				☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			

Dart Aerospace Ltd.
1270 Aberdeen Street
Newbury, ON K6A 1K7
CANADA
TEL: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com



Container No: S165597



Part: D5331-041

Job No: 187738

Serial No/Batch: S165597

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 03/25/19